

# Work Order ID 83594

Thursday, April 19, 2012 3:54:31 PM

**\*83594\***

Page 1

Item ID: D4097-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Armrest Assembly

Start Date: 4/19/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

*MUF*

Date: *12-04-19* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4097	A								
100		0.00							
<b>*100*</b>									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <i>PPP</i>	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging									

*1x*

*Ø*

*P12/04/12*

*Szlkx/24*

*(X)*

*P12/25 (1)*

*83594*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83594**

Thursday, April 19, 2012 3:54:31 PM

**\*83594\***

Page 2

Item ID: D4097-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Armrest Assembly

Stop **\*NS2\***

Start Date: 4/19/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

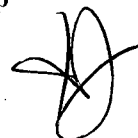
**\*130\***

QC

Memo

0.00

Quality Control

12/4/25 

11-01-25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 19, 2012 3:54:30 PM

Page 1

Work Order ID: 83594

Parent Item: D4097-041

Parent Item Name: Armrest Assembly

Start Date: 4/19/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A as per ECN10-573 DD 10.05:18 verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3696-041 Arm Assembly		Manufactured	No			100	Each	5.0000	1	1		EP 12/04/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST262		5							
				58895		5							
D4098-041 Armrest Cushion Assembly		Manufactured	No			100	Each	3.0000	1	1		EP 12/04/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST261		3							
				58885		3							
D4099-1 Bracket		Manufactured	No			100	Each	0.0000	1	1		EP 12/04/12	
MS21042L3 Nut		Purchased	No			100	Each	2,805.0000	3	3		EP 12/04/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300		2805							
				117441		16							
				117885		32							
				118451		5							
				118927		3							
				119017		1591							
				119075		158							
				121349		1000							
MS24693-C273 Screw		Purchased	No			100	Each	130.0000	5	5		EP 12/04/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST310		130							
				114752		5							
				120308		25							
				121060		100							

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 19, 2012 3:54:30 PM

Page 2

Work Order ID: 83594

Parent Item: D4097-041

Parent Item Name: Armrest Assembly

Start Date: 4/19/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

MS24693-C277

Purchased

No

100

Each

51.0000

3

3

Screw

Location

Loc Qty

Loc Code

ST310

51

109297 -

15

113644

36

NAS1149D0332J

Purchased

No

Each

2,887.0000

3

Washer

Location

Loc Qty

Loc Code

ST298

2887

105793

12

110985

4

117087

89

119042

38

119717

544

120644

215

121011

1985

3

Thursday, April 19, 2012 3:54:30 PM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

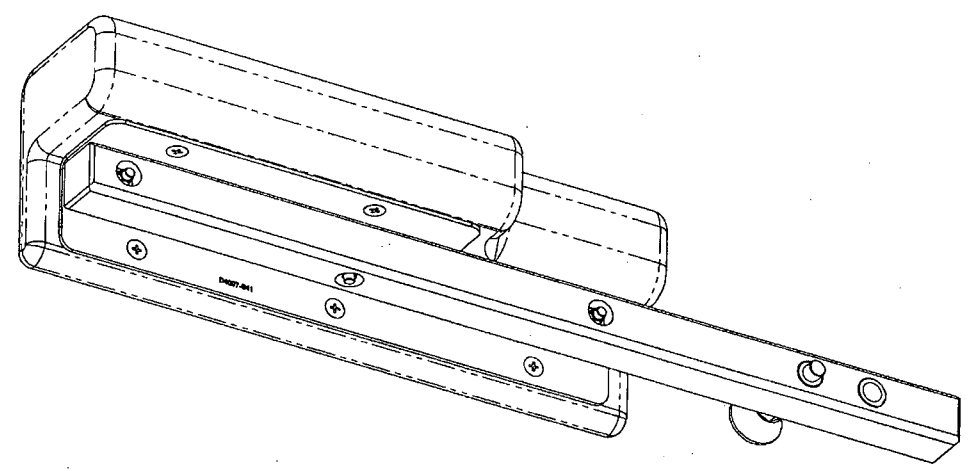
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4097-041	ARMREST ASSEMBLY
2	1	D3696-041	ARM ASSEMBLY
3	1	D4098-041	CUSHION ASSEMBLY
4	1	D4099-1	BRACKET
5	3	MS21042L3	NUT
6	5	MS24693-C273	SCREW
7	3	MS24693-C277	SCREW
8	3	NAS1149D0332J	WASHER (OR AN960JD10L)



**D4097-041 ARMREST ASSEMBLY**

**RELEASED**  
2010-05-17  
MND

504  
83

A		NEW ISSUE		MB		10.05.07	
REV.		DESCRIPTION		BY	DATE		
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A		SHEET 1 OF 2	
DRAWN							
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.		DRAWING NO. <b>D4097</b>		TITLE <b>ARMREST ASSEMBLY</b>		SCALE NTS	
DATE	10.05.07		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

8 7 6 5 4 3 2 1

# Dart Aerospace Ltd

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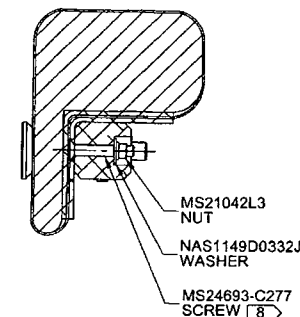
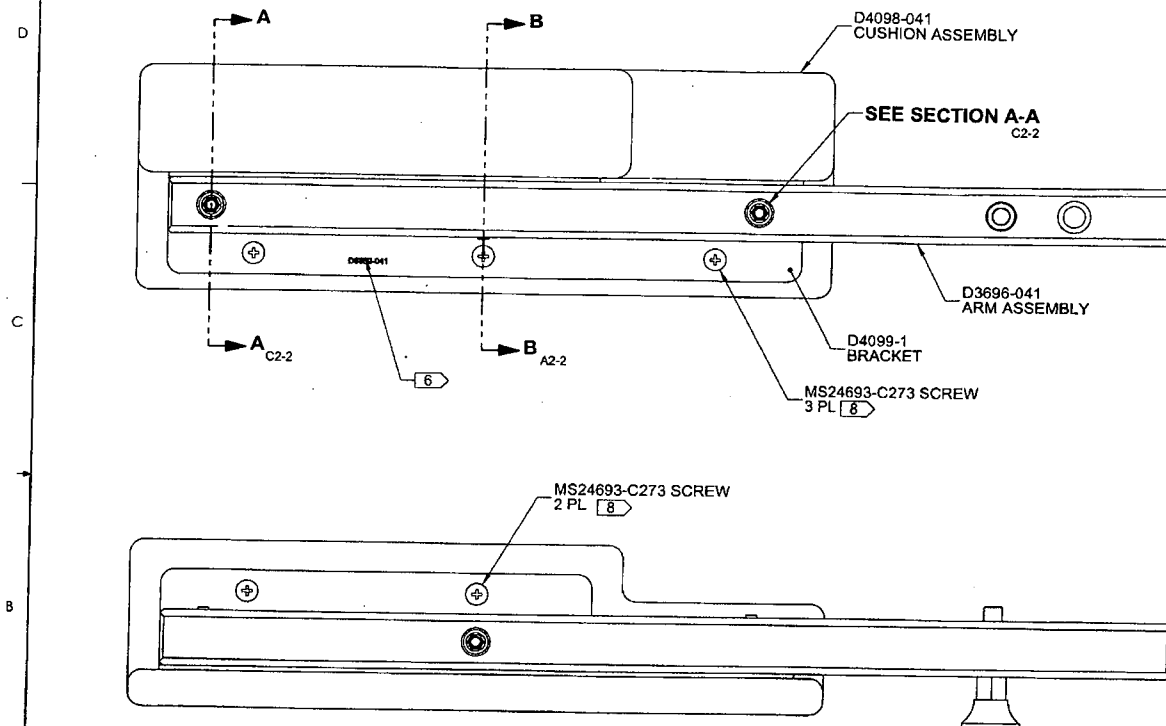
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

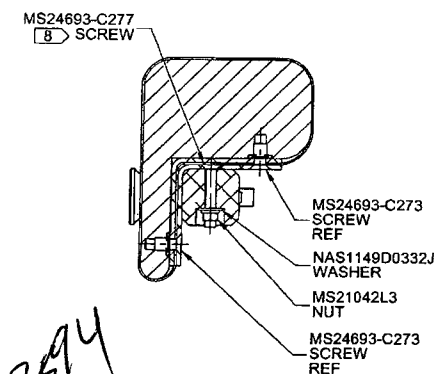
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8 7 6 5 4 3 2 1



SECTION A-A  
C7-2  
D4-2



SECTION B-B  
C6-2

**RELEASED**  
2010-05-17

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4097-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 2.66 lbs
- 8) TORQUE SCREWS TO 20-25 in-lb.

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4097	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	10.05.07 -	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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